



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

**D2573**  
**Job Sheet 175175**



Part No: D2573

Job Qty: 10 ea

Part Name: Saddle, Aft, Out



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/28/18

Job Tracking No:

Due Date: 4/13/18 30 21

Created By: Marie Lajeunesse

Type: SOLD 9-89

Description:

Note: DWG REV F IPP: I As Per RevE 06-01-27 JLM

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation              | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off                |
|-------|------------------------|--------|------------|----------|-----------|---------|-----------------------|-----------|-------------------------|
|       |                        |        |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |                         |
| 90    | Start up Operation     | 10 Ea  |            | 4/12/18  | 0.00      | 0.00    | Start Up Machining    |           | SB 18/04/05             |
| 100   | CNC Vertical Machining | 10 pcs |            | 4/12/18  | 1.01      | 16.67   | HAAS 1                |           | UH 18/04/13             |
| 110   | Mill Conv              | 10 pcs |            | 4/12/18  | 0.00      | 1.67    | Mill Conv 1           |           | UH                      |
| 130   | QC                     | 10 pcs |            | 4/12/18  | 0.00      | 0.00    | QC8                   |           | 21 18/04/18             |
| 140   | HandFinish             | 10 pcs |            | 4/12/18  | 0.00      | 0.47    | HandFinish1           |           | SA 18-04-19             |
| 150   | Powdercoat             | 10 pcs |            | 4/13/18  | 0.00      | 0.38    | Powdercoat1           |           | BD 18-4-19              |
| 160   | QC                     | 10 pcs |            | 4/13/18  | 0.00      | 0.00    | QC3                   |           | 11 APR 19 2018          |
| 170   | Packaging              | 10 pcs |            | 4/13/18  | 0.00      | 0.00    | Packaging3            |           | 51398 DAS 6 APR 25 2018 |
| 180   | QC21-SA                | 10 Ea  |            | 4/13/18  | 0.00      | 0.00    | QC21                  |           | 9-89 21 APR 25 2018     |

Part Op 100 - Program Batch No.

Descriptions: 110 - Machine keyway as per dwg D2573 & D2574

150 - START TIME: 2:40 O.V.T: 3:20 FINISH: 3:10 - M13867

### Job BOM

| Part / Item | Component Name | Quantity     | Operation             | Container |
|-------------|----------------|--------------|-----------------------|-----------|
| D6101-007   | Saddle Billet  | 10 Ea (1 ea) | 90-Start up Operation |           |

5055150 -> 5055150

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | D6101-007      | 10       | 20        | 0         |

### Part Specifications

| Spec No | Description          | Target/Tolerance                  | Limits         | Type | Special Comments |
|---------|----------------------|-----------------------------------|----------------|------|------------------|
| 1       | Saddle, Aft Outboard | 0.438Inches<br>+ 0.005<br>- 0.000 | 0.443<br>0.438 |      |                  |
| 2       | Saddle, Aft Outboard | 1.745Inches<br>+ 0.010<br>- 0.000 | 1.755<br>1.745 |      |                  |
| 3       | Saddle, Aft Outboard | 3.495Inches<br>+ 0.010<br>- 0.000 | 3.505<br>3.495 |      |                  |
| 4       | Saddle, Aft Outboard | 1.745Inches<br>+ 0.010<br>- 0.000 | 1.755<br>1.745 |      |                  |
| 5       | Saddle, Aft Outboard | 7.990Inches<br>+ 0.020<br>- 0.000 | 8.010<br>7.990 |      |                  |

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

|                                                              |                      |                          |                                   |                          |            |                          |                     |                          |             |                          |
|--------------------------------------------------------------|----------------------|--------------------------|-----------------------------------|--------------------------|------------|--------------------------|---------------------|--------------------------|-------------|--------------------------|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____ | <b>DISPOSITION</b>   |                          | <b>AGAINST DEPARTMENT/PROCESS</b> |                          |            |                          |                     |                          |             |                          |
|                                                              | Rework               | <input type="checkbox"/> | Skid-tube                         | <input type="checkbox"/> | Cross tube | <input type="checkbox"/> | Water Jet           | <input type="checkbox"/> | Engineering | <input type="checkbox"/> |
|                                                              | Scrap                | <input type="checkbox"/> | Machining                         | <input type="checkbox"/> | Small Fab  | <input type="checkbox"/> | Prod. Eng. Coord.   | <input type="checkbox"/> | Quality     | <input type="checkbox"/> |
|                                                              | Use-as-is            | <input type="checkbox"/> | Thermoforming                     | <input type="checkbox"/> | Finishing  | <input type="checkbox"/> | Rec/Store/Packaging | <input type="checkbox"/> | Other       | <input type="checkbox"/> |
|                                                              | Suspected Unapproved | <input type="checkbox"/> | Large Fab                         | <input type="checkbox"/> | Composite  | <input type="checkbox"/> | Supplier            | <input type="checkbox"/> |             |                          |

|        |         |                 |                       |
|--------|---------|-----------------|-----------------------|
| Date : | Step #: | QTY Effective : | MRB (QSI042) Approval |
|--------|---------|-----------------|-----------------------|

### Description Work Order Deviation

Dart Aerospace Ltd.  
 1270 Aberdeen Street  
 Wexford, ON K8A 1K7  
 CANADA  
 TEL: 1 813 832-5200  
 Email: sales@dartaero.com  
 www.dartaerospace.com

Date: 04/05/18



Container No: S058306

Part: D2573

Job No: 175175

Serial No/Batch: S058306

Revision: \_\_\_\_\_

Inspector: \_\_\_\_\_

| Root Cause         |                          |                       |                          |
|--------------------|--------------------------|-----------------------|--------------------------|
| Environment        | <input type="checkbox"/> | No Re-verification    | <input type="checkbox"/> |
| Design             | <input type="checkbox"/> | Operator              | <input type="checkbox"/> |
| Doc/Data           | <input type="checkbox"/> | Offset/Setup          | <input type="checkbox"/> |
| Equip/Tooling      | <input type="checkbox"/> | Supplier              | <input type="checkbox"/> |
| Handling/Pre       | <input type="checkbox"/> | Training              | <input type="checkbox"/> |
| Material           | <input type="checkbox"/> | Use for Testing       | <input type="checkbox"/> |
| Internal Transport | <input type="checkbox"/> | Poor Information      | <input type="checkbox"/> |
| Tribal Knowledge   | <input type="checkbox"/> | Rushing               | <input type="checkbox"/> |
| LOA                | <input type="checkbox"/> | Product Improvement   | <input type="checkbox"/> |
| Substation         | <input type="checkbox"/> | Process Improvement   | <input type="checkbox"/> |
| Past Expiry Date   | <input type="checkbox"/> | Manufacturing Process | <input type="checkbox"/> |
| Misidentified      | <input type="checkbox"/> | Past Due              | <input type="checkbox"/> |
| OTHER :            |                          |                       |                          |

- ☐ Pressure/Forced
- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Wave/Twist in Tube
- ☐ Marks/Chatter

- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Instructions Incomplete/Unclear
- ☐ Drill Holes

- ☐ Out of Sequence
- ☐ Off-set
- ☐ Mislabeled
- ☐ Fit/Function
- ☐ Misaligned/off center

- ☐ Part Moved
- ☐ Drawing
- ☐ Finish
- ☐ Misread
- ☐ Turning Sequence



|    |                      |             |                    |                |
|----|----------------------|-------------|--------------------|----------------|
| 6  | Saddle, Aft Outboard | 0.490Inches | + 0.020<br>- 0.000 | 0.510<br>0.490 |
| 7  | Saddle, Aft Outboard | 0.257Inches | + 0.005<br>- 0.000 | 0.262<br>0.257 |
| 8  | Saddle, Aft Outboard | 0.375Inches | + 0.005<br>- 0.000 | 0.380<br>0.375 |
| 9  | Saddle, Aft Outboard | 0.490Inches | + 0.020<br>- 0.000 | 0.510<br>0.490 |
| 10 | Saddle, Aft Outboard | 1.174Inches | + 0.010<br>- 0.000 | 1.184<br>1.174 |
| 11 | Saddle, Aft Outboard | 0.558Inches | + 0.020<br>- 0.000 | 0.578<br>0.558 |
| 12 | Saddle, Aft Outboard | 1.174Inches | + 0.010<br>- 0.000 | 1.184<br>1.174 |
| 13 | Saddle, Aft Outboard | 1.365Inches | + 0.010<br>- 0.000 | 1.375<br>1.365 |
| 14 | Saddle, Aft Outboard | 2.495Inches | + 0.010<br>- 0.000 | 2.505<br>2.495 |
| 15 | Saddle, Aft Outboard | 4.119Inches | + 0.010<br>- 0.000 | 4.129<br>4.119 |
| 16 | Saddle, Aft Outboard | 0.115Inches | + 0.020<br>- 0.000 | 0.135<br>0.115 |
| 17 | Saddle, Aft Outboard | 0.115Inches | + 0.020<br>- 0.000 | 0.135<br>0.115 |
| 18 | Saddle, Aft Outboard | 0.240Inches | + 0.020<br>- 0.000 | 0.260<br>0.240 |
| 19 | Saddle, Aft Outboard | 0.115Inches | + 0.020<br>- 0.000 | 0.135<br>0.115 |
| 20 | Saddle, Aft Outboard | 0.178Inches | + 0.020<br>- 0.000 | 0.198<br>0.178 |
| 21 | Saddle, Aft Outboard | 3.210Inches | + 0.040<br>- 0.000 | 3.250<br>3.210 |
| 22 | Saddle, Aft Outboard | 0.230Inches | + 0.020<br>- 0.000 | 0.250<br>0.230 |
| 23 | Saddle, Aft Outboard | 0.115Inches | + 0.020<br>- 0.000 | 0.135<br>0.115 |
| 24 | Saddle, Aft Outboard | 0.308Inches | + 0.005<br>- 0.000 | 0.313<br>0.308 |
| 25 | Saddle, Aft Outboard | 0.760Inches | + 0.005<br>- 0.000 | 0.765<br>0.760 |
| 26 | Saddle, Aft Outboard | 0.352Inches | + 0.020<br>- 0.000 | 0.372<br>0.352 |
| 27 | Saddle, Aft Outboard | 0.470Inches | + 0.060<br>- 0.000 | 0.530<br>0.470 |
| 28 | Saddle, Aft Outboard | 0.615Inches | + 0.020<br>- 0.000 | 0.635<br>0.615 |
| 29 | Saddle, Aft Outboard | 0.053Inches | + 0.020<br>- 0.000 | 0.073<br>0.053 |
| 30 | Saddle, Aft Outboard | 0.240Inches | + 0.020<br>- 0.000 | 0.260<br>0.240 |
| 31 | Saddle, Aft Outboard | 1.500Inches | + 0.020<br>- 0.000 | 1.520<br>1.500 |
| 32 | Saddle, Aft Outboard | 0.115Inches | + 0.020<br>- 0.000 | 0.135<br>0.115 |
| 33 | Saddle, Aft Outboard | 0.240Inches | + 0.040<br>- 0.000 | 0.280<br>0.240 |
| 34 | Saddle, Aft Outboard | 0.240Inches | + 0.020<br>- 0.000 | 0.260<br>0.240 |
| 35 | Saddle, Aft Outboard | 2.000Inches | + 0.020<br>- 0.000 | 2.020<br>2.000 |
| 36 | Saddle, Aft Outboard | 0.023Inches | + 0.020<br>- 0.000 | 0.043<br>0.023 |

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

|                                                              |  |                                                                                                                                                                                    |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |  |  |                                                                                                                   |                                                 |  |
|--------------------------------------------------------------|--|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--|-------------------------------------------------------------------------------------------------------------------|-------------------------------------------------|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____ |  | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/> |  | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>             Skid-tube <input type="checkbox"/><br/>             Machining <input type="checkbox"/><br/>             Thermoforming <input type="checkbox"/><br/>             Large Fab <input type="checkbox"/> </div> <div>             Cross tube <input type="checkbox"/><br/>             Small Fab <input type="checkbox"/><br/>             Finishing <input type="checkbox"/><br/>             Composite <input type="checkbox"/> </div> <div>             Water Jet <input type="checkbox"/><br/>             Prod. Eng. Coord. <input type="checkbox"/><br/>             Rec/Store/Packaging <input type="checkbox"/><br/>             Supplier <input type="checkbox"/> </div> <div>             Engineering <input type="checkbox"/><br/>             Quality <input type="checkbox"/><br/>             Other <input type="checkbox"/> </div> </div> |  |  |                                                                                                                   |                                                 |  |
| Date :                                                       |  | Step #:                                                                                                                                                                            |  | QTY Effective :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |  |  | <b>MRB (QSI042) Approval</b><br><br><div style="border: 1px solid black; height: 150px; margin-top: 10px;"></div> |                                                 |  |
| Description Work Order Deviation                             |  |                                                                                                                                                                                    |  | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |  |  |                                                                                                                   |                                                 |  |
|                                                              |  |                                                                                                                                                                                    |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |  |  |                                                                                                                   |                                                 |  |
|                                                              |  |                                                                                                                                                                                    |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |  |  |                                                                                                                   |                                                 |  |
|                                                              |  |                                                                                                                                                                                    |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |  |  |                                                                                                                   | Completed By                                    |  |
|                                                              |  |                                                                                                                                                                                    |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |  |  |                                                                                                                   | Lead hand / Supervisor<br>Approval Verification |  |
|                                                              |  |                                                                                                                                                                                    |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |  |  |                                                                                                                   | QC / QA Coordinator<br>Approval                 |  |

| Root Cause                            |                                     |                                             |                                           | FAULT CATEGORY                                  |                                                            |                                                |                                               |
|---------------------------------------|-------------------------------------|---------------------------------------------|-------------------------------------------|-------------------------------------------------|------------------------------------------------------------|------------------------------------------------|-----------------------------------------------|
| Environment <input type="checkbox"/>  | Design <input type="checkbox"/>     | Doc/Data <input type="checkbox"/>           | Equip/Tooling <input type="checkbox"/>    | Pressure/Forced <input type="checkbox"/>        | Temperature/Cure <input type="checkbox"/>                  | Power Loss/Surge <input type="checkbox"/>      | Positioned Wrong <input type="checkbox"/>     |
| Handling/Pre <input type="checkbox"/> | Material <input type="checkbox"/>   | Internal Transport <input type="checkbox"/> | Tribal Knowledge <input type="checkbox"/> | Bending <input type="checkbox"/>                | Set-up <input type="checkbox"/>                            | Folio/Program <input type="checkbox"/>         | Outside Dimensions <input type="checkbox"/>   |
| LOA <input type="checkbox"/>          | Substation <input type="checkbox"/> | Past Expiry Date <input type="checkbox"/>   | Misidentified <input type="checkbox"/>    | Centre Not Concentric <input type="checkbox"/>  | BOM/Route <input type="checkbox"/>                         | Grain <input type="checkbox"/>                 | Over/Under tolerance <input type="checkbox"/> |
|                                       |                                     |                                             |                                           | Cracks <input type="checkbox"/>                 | Broken/Damage/Defect <input type="checkbox"/>              | Weld <input type="checkbox"/>                  | Part Incorrect <input type="checkbox"/>       |
|                                       |                                     |                                             |                                           | Crimp/Kink/Ripple/Wave <input type="checkbox"/> | Inspection Incomplete/Unqualified <input type="checkbox"/> | Wrong Stock Pulled <input type="checkbox"/>    | Part Lost/Missing <input type="checkbox"/>    |
|                                       |                                     |                                             |                                           | Cuffs <input type="checkbox"/>                  | Contamination <input type="checkbox"/>                     | Out of Sequence <input type="checkbox"/>       | Part Moved <input type="checkbox"/>           |
|                                       |                                     |                                             |                                           | Crushing <input type="checkbox"/>               | Countersink <input type="checkbox"/>                       | Off-set <input type="checkbox"/>               | Drawing <input type="checkbox"/>              |
|                                       |                                     |                                             |                                           | Heat Treat <input type="checkbox"/>             | Cut Too Short <input type="checkbox"/>                     | Mislabeled <input type="checkbox"/>            | Finish <input type="checkbox"/>               |
|                                       |                                     |                                             |                                           | Wave/Twist in Tube <input type="checkbox"/>     | Instructions Incomplete/Unclear <input type="checkbox"/>   | Fit/Function <input type="checkbox"/>          | Misread <input type="checkbox"/>              |
|                                       |                                     |                                             |                                           | Marks/Chatter <input type="checkbox"/>          | Drill Holes <input type="checkbox"/>                       | Misaligned/off center <input type="checkbox"/> | Turning Sequence <input type="checkbox"/>     |
|                                       |                                     |                                             |                                           | OTHER : <input type="checkbox"/>                |                                                            |                                                |                                               |



|                                          |                            |
|------------------------------------------|----------------------------|
| <b>DART AEROSPACE LTD</b>                | <b>Work Order:</b> 175 175 |
| <b>Description:</b> Saddle, Aft Outboard | <b>Part Number:</b> D2573  |
| <b>Inspection Dwg:</b> D2573 Rev. F      | <b>Page 1 of 1</b>         |

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

| Dim           | Min   | Max   | Go/No Go Gauge | Recorded Actual Dimensions |       |       |        | By | Date |
|---------------|-------|-------|----------------|----------------------------|-------|-------|--------|----|------|
|               |       |       |                | 1                          | 2     | 3     | 4      |    |      |
| A             | 0.438 | 0.443 |                | 0.438                      | 0.438 | 0.438 | 0.438  |    |      |
| B             | 1.745 | 1.755 |                | 1.750                      | 1.750 | 1.750 | 1.750  |    |      |
| C             | 3.495 | 3.505 |                | 3.500                      | 3.500 | 3.500 | 3.500  |    |      |
| D             | 1.745 | 1.755 |                | 1.750                      | 1.750 | 1.750 | 1.750  |    |      |
| E             | 7.990 | 8.010 |                | 8.000                      | 8.001 | 8.002 | 8.002  |    |      |
| F             | 0.490 | 0.510 |                | 0.503                      | 0.500 | 0.503 | 0.502  |    |      |
| G             | 0.257 | 0.262 |                | 0.257                      | 0.257 | 0.257 | 0.257  |    |      |
| H             | 0.375 | 0.380 |                | 0.375                      | 0.375 | 0.375 | 0.375  |    |      |
| I             | 0.490 | 0.510 |                | 0.500                      | 0.501 | 0.500 | 0.5015 |    |      |
| J             | 1.174 | 1.184 |                | 1.179                      | 1.179 | 1.179 | 1.179  |    |      |
| K             | 0.558 | 0.578 |                | 0.568                      | 0.569 | 0.569 | 0.568  |    |      |
| L             | 1.174 | 1.184 |                | 1.179                      | 1.179 | 1.179 | 1.179  |    |      |
| M             | 1.365 | 1.375 |                | 1.370                      | 1.370 | 1.370 | 1.37   |    |      |
| N             | 2.495 | 2.505 |                | 2.500                      | 2.500 | 2.500 | 2.500  |    |      |
| O             | 4.119 | 4.129 |                | 4.123                      | 4.123 | 4.124 | 4.123  |    |      |
| P             | 0.115 | 0.135 |                | 0.130                      | 0.132 | 0.130 | 0.130  |    |      |
| Q             | 0.115 | 0.135 |                | 0.125                      | 0.125 | 0.124 | 0.124  |    |      |
| R             | 0.240 | 0.260 |                | 0.252                      | 0.252 | 0.252 | 0.252  |    |      |
| S             | 0.115 | 0.135 |                | 0.125                      | 0.128 | 0.126 | 0.128  |    |      |
| T             | 0.178 | 0.198 |                | 0.188                      | 0.188 | 0.188 | 0.188  |    |      |
| U             | 3.210 | 3.250 |                | 3.230                      | 3.230 | 3.230 | 3.230  |    |      |
| V             | 0.230 | 0.250 |                | 0.239                      | 0.241 | 0.240 | 0.241  |    |      |
| W             | 0.115 | 0.135 |                | 0.124                      | 0.124 | 0.124 | 0.130  |    |      |
| X             | 0.308 | 0.313 |                | 0.311                      | 0.311 | 0.311 | 0.310  |    |      |
| Y             | 0.760 | 0.765 |                | 0.760                      | 0.761 | 0.761 | 0.761  |    |      |
| Z             | 0.352 | 0.372 |                | 0.366                      | 0.364 | 0.363 | 0.363  |    |      |
| AA            | 0.470 | 0.530 |                | 0.500                      | 0.500 | 0.500 | 0.500  |    |      |
| AB            | 0.615 | 0.635 |                | 0.627                      | 0.627 | 0.627 | 0.627  |    |      |
| AC            | 0.053 | 0.073 |                | 0.061                      | 0.070 | 0.068 | 0.063  |    |      |
| AD            | 0.240 | 0.260 |                | 0.247                      | 0.252 | 0.252 | 0.257  |    |      |
| AE            | 1.500 | 1.520 |                | 1.510                      | 1.510 | 1.510 | 1.500  |    |      |
| AF            | 0.115 | 0.135 |                | 0.125                      | 0.122 | 0.125 | 0.123  |    |      |
| AG            | 0.240 | 0.280 |                | 0.252                      | 0.250 | 0.250 | 0.250  |    |      |
| AH            | 0.240 | 0.260 |                | 0.250                      | 0.250 | 0.250 | 0.250  |    |      |
| AI            | 2.000 | 2.020 |                | 2.000                      | 2.000 | 2.000 | 2.000  |    |      |
| AJ            | 0.023 | 0.043 |                | 0.033                      | 0.033 | 0.033 | 0.033  |    |      |
| Accept/Reject |       |       |                |                            |       |       |        |    |      |

|                             |
|-----------------------------|
| <b>Measured by:</b> SBL/gmk |
| <b>Date:</b> 18/04/05       |

|                                |
|--------------------------------|
| <b>Audited by:</b> [Signature] |
| <b>Date:</b> 18/04/18          |

| Rev | Date     | Change                                  | Revised by | Approved |
|-----|----------|-----------------------------------------|------------|----------|
| B   | 02.09.26 | Re-format; Added Rev. D                 | KJ         |          |
| C   | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ         |          |
| D   | 05.05.05 | Added dimension AI                      | KJ/RF      |          |
| E   | 05.12.05 | Added dimension AJ                      | KJ/JLM     |          |
| F   | 13.03.07 | Dwg Rev updated                         | KJ         |          |



|                                          |  |                           |  |
|------------------------------------------|--|---------------------------|--|
| <b>DART AEROSPACE LTD</b>                |  | <b>Work Order:</b>        |  |
| <b>Description:</b> Saddle, Aft Outboard |  | <b>Part Number:</b> D2573 |  |
| <b>Inspection Dwg:</b> D2573 Rev. F      |  | <b>Page 1 of 1</b>        |  |

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

|     |       |       |                | Recorded Actual Dimensions |                    |                    |       | By | Date |
|-----|-------|-------|----------------|----------------------------|--------------------|--------------------|-------|----|------|
| Dim | Min   | Max   | Go/No Go Gauge | 5                          | 26                 | 27                 | 48    |    |      |
| A   | 0.438 | 0.443 |                | 0.438                      | 0.438              | 0.438              | 0.438 |    |      |
| B   | 1.745 | 1.755 |                | 1.750                      | 1.750              | 1.750              | 1.750 |    |      |
| C   | 3.495 | 3.505 |                | 3.500                      | 3.500              | 3.500              | 3.500 |    |      |
| D   | 1.745 | 1.755 |                | 1.750                      | 1.750              | 1.750              | 1.750 |    |      |
| E   | 7.990 | 8.010 |                | 8.001                      | 8.002              | 8.001              |       |    |      |
| F   | 0.490 | 0.510 |                | 0.501 <sup>5</sup>         | 0.501              | 0.502              |       |    |      |
| G   | 0.257 | 0.262 |                | 0.257                      | 0.257              | 0.257              | 0.257 |    |      |
| H   | 0.375 | 0.380 |                | 0.375                      | 0.375              | 0.375              | 0.375 |    |      |
| I   | 0.490 | 0.510 |                | 0.503 <sup>5</sup>         | 0.5005             | 0.502 <sup>5</sup> |       |    |      |
| J   | 1.174 | 1.184 |                | 1.179                      | 1.179              | 1.179              | 1.179 |    |      |
| K   | 0.558 | 0.578 |                | 0.570                      | 0.567 <sup>5</sup> | 0.568 <sup>5</sup> |       |    |      |
| L   | 1.174 | 1.184 |                | 1.179                      | 1.179              | 1.179              | 1.179 |    |      |
| M   | 1.365 | 1.375 |                | 1.370                      | 1.370              | 1.370              | 1.370 |    |      |
| N   | 2.495 | 2.505 |                | 2.500                      | 2.500              | 2.500              | 2.500 |    |      |
| O   | 4.119 | 4.129 |                | 4.124                      | 4.124              | 4.124              | 4.124 |    |      |
| P   | 0.115 | 0.135 |                | 0.132                      | 0.130              | 0.132              |       |    |      |
| Q   | 0.115 | 0.135 |                | 0.124                      | 0.124              | 0.124              | 0.124 |    |      |
| R   | 0.240 | 0.260 |                | 0.250                      | 0.250              | 0.250              | 0.250 |    |      |
| S   | 0.115 | 0.135 |                | 0.130                      | 0.129              | 0.129              |       |    |      |
| T   | 0.178 | 0.198 |                | 0.188                      | 0.188              | 0.188              | 0.188 |    |      |
| U   | 3.210 | 3.250 |                | 3.230                      | 3.230              | 3.230              | 3.230 |    |      |
| V   | 0.230 | 0.250 |                | 0.240                      | 0.240              | 0.240              |       |    |      |
| W   | 0.115 | 0.135 |                | 0.130                      | 0.130              | 0.130              |       |    |      |
| X   | 0.308 | 0.313 |                | 0.311                      | 0.311 <sup>5</sup> | 0.311              |       |    |      |
| Y   | 0.760 | 0.765 |                | 0.760                      | 0.760              | 0.760              | 0.760 |    |      |
| Z   | 0.352 | 0.372 |                | 0.363                      | 0.363              | 0.364              |       |    |      |
| AA  | 0.470 | 0.530 |                | 0.500                      | 0.500              | 0.500              | 0.500 |    |      |
| AB  | 0.615 | 0.635 |                | 0.630                      | 0.628              | 0.629              |       |    |      |
| AC  | 0.053 | 0.073 |                | 0.063                      | 0.063              | 0.063              | 0.063 |    |      |
| AD  | 0.240 | 0.260 |                | 0.252                      | 0.251              | 0.252              |       |    |      |
| AE  | 1.500 | 1.520 |                | 1.500                      | 1.500              | 1.500              | 1.500 |    |      |
| AF  | 0.115 | 0.135 |                | 0.125                      | 0.125              | 0.125              |       |    |      |
| AG  | 0.240 | 0.280 |                | 0.250                      | 0.250              | 0.250              | 0.250 |    |      |
| AH  | 0.240 | 0.260 |                | 0.250                      | 0.250              | 0.250              |       |    |      |
| AI  | 2.000 | 2.020 |                | 2.000                      | 2.000              | 2.000              | 2.000 |    |      |
| AJ  | 0.023 | 0.043 |                | 0.033                      | 0.033              | 0.033              | 0.033 |    |      |

Accept/Reject

|                         |
|-------------------------|
| Measured by: <u>SBC</u> |
| Date: <u>18/04/06</u>   |

|                                |
|--------------------------------|
| Audited by: <u>[Signature]</u> |
| Date: <u>18/04/06</u>          |

| Rev | Date     | Change                                  | Revised by | Approved |
|-----|----------|-----------------------------------------|------------|----------|
| B   | 02.09.26 | Re-format; Added Rev. D                 | KJ         |          |
| C   | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ         |          |
| D   | 05.05.05 | Added dimension AI                      | KJ/RF      |          |
| E   | 05.12.05 | Added dimension AJ                      | KJ/JLM     |          |
| F   | 13.03.07 | Dwg Rev updated                         | KJ         |          |



|                                          |  |                           |  |
|------------------------------------------|--|---------------------------|--|
| <b>DART AEROSPACE LTD</b>                |  | <b>Work Order:</b>        |  |
| <b>Description:</b> Saddle, Aft Outboard |  | <b>Part Number:</b> D2573 |  |
| <b>Inspection Dwg:</b> D2573 Rev. F      |  | <b>Page 1 of 1</b>        |  |

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

|     |       |       |                | Recorded Actual Dimensions |        |   |   | By | Date |
|-----|-------|-------|----------------|----------------------------|--------|---|---|----|------|
| Dim | Min   | Max   | Go/No Go Gauge | 1 9                        | 2 10   | 3 | 4 |    |      |
| A   | 0.438 | 0.443 |                | 0.438                      | 0.438  |   |   |    |      |
| B   | 1.745 | 1.755 |                | 1.750                      | 1.750  |   |   |    |      |
| C   | 3.495 | 3.505 |                | 3.500                      | 3.500  |   |   |    |      |
| D   | 1.745 | 1.755 |                | 1.750                      | 1.750  |   |   |    |      |
| E   | 7.990 | 8.010 |                | 8.001                      | 8.001  |   |   |    |      |
| F   | 0.490 | 0.510 |                | 0.498                      | 0.499  |   |   |    |      |
| G   | 0.257 | 0.262 |                | 0.257                      | 0.257  |   |   |    |      |
| H   | 0.375 | 0.380 |                | 0.375                      | 0.375  |   |   |    |      |
| I   | 0.490 | 0.510 |                | 0.501                      | 0.501  |   |   |    |      |
| J   | 1.174 | 1.184 |                | 1.179                      | 1.179  |   |   |    |      |
| K   | 0.558 | 0.578 |                | 0.503                      | 0.5085 |   |   |    |      |
| L   | 1.174 | 1.184 |                | 1.179                      | 1.179  |   |   |    |      |
| M   | 1.365 | 1.375 |                | 1.370                      | 1.370  |   |   |    |      |
| N   | 2.495 | 2.505 |                | 2.500                      | 2.500  |   |   |    |      |
| O   | 4.119 | 4.129 |                | 4.124                      | 4.124  |   |   |    |      |
| P   | 0.115 | 0.135 |                | 0.125                      | 0.125  |   |   |    |      |
| Q   | 0.115 | 0.135 |                | 0.124                      | 0.124  |   |   |    |      |
| R   | 0.240 | 0.260 |                | 0.250                      | 0.250  |   |   |    |      |
| S   | 0.115 | 0.135 |                | 0.125                      | 0.125  |   |   |    |      |
| T   | 0.178 | 0.198 |                | 0.188                      | 0.188  |   |   |    |      |
| U   | 3.210 | 3.250 |                | 3.230                      | 3.230  |   |   |    |      |
| V   | 0.230 | 0.250 |                | 0.240                      | 0.240  |   |   |    |      |
| W   | 0.115 | 0.135 |                | 0.125                      | 0.125  |   |   |    |      |
| X   | 0.308 | 0.313 |                | 0.311                      | 0.3105 |   |   |    |      |
| Y   | 0.760 | 0.765 |                | 0.760                      | 0.760  |   |   |    |      |
| Z   | 0.352 | 0.372 |                | 0.363                      | 0.363  |   |   |    |      |
| AA  | 0.470 | 0.530 |                | 0.500                      | 0.500  |   |   |    |      |
| AB  | 0.615 | 0.635 |                | 0.628                      | 0.628  |   |   |    |      |
| AC  | 0.053 | 0.073 |                | 0.063                      | 0.063  |   |   |    |      |
| AD  | 0.240 | 0.260 |                | 0.250                      | 0.250  |   |   |    |      |
| AE  | 1.500 | 1.520 |                | 1.500                      | 1.500  |   |   |    |      |
| AF  | 0.115 | 0.135 |                | 0.130                      | 0.130  |   |   |    |      |
| AG  | 0.240 | 0.280 |                | 0.250                      | 0.250  |   |   |    |      |
| AH  | 0.240 | 0.260 |                | 0.250                      | 0.250  |   |   |    |      |
| AI  | 2.000 | 2.020 |                | 2.000                      | 2.000  |   |   |    |      |
| AJ  | 0.023 | 0.043 |                | 0.033                      | 0.033  |   |   |    |      |

Accept/Reject

|                     |            |
|---------------------|------------|
| <b>Measured by:</b> | <i>VHS</i> |
| <b>Date:</b>        | 18/4/18    |

|                    |              |
|--------------------|--------------|
| <b>Audited by:</b> | <i>m gyl</i> |
| <b>Date:</b>       | 18/04/18     |

| Rev | Date     | Change                                  | Revised by | Approved           |
|-----|----------|-----------------------------------------|------------|--------------------|
| B   | 02.09.26 | Re-format; Added Rev. D                 | KJ         |                    |
| C   | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ         |                    |
| D   | 05.05.05 | Added dimension AI                      | KJ/RF      |                    |
| E   | 05.12.05 | Added dimension AJ                      | KJ/JLM     |                    |
| F   | 13.03.07 | Dwg Rev updated                         | KJ         | <i>[Signature]</i> |